

731-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:39:06 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MECHANICAL GROUND HANDLING WHEEL KIT
Job Number : 47363A	
Estimate Number : 12136	
P.O. Number :	Part Number : D206731041
This Issue : 22/04/2009 S.O. No. :	Drawing Number : DSK 093 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 47362A	Material :
Written By :	Due Date : 05/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JULIO 09.04.22</u>	
Comment : est rev. A 01.02.01 new issue EC	
Est Rev:B As per Rev B 07-02-13 JLM	
est rev C 07.05.14 rev C IIN Ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	<u>B47614</u>

SAD

09-05-14

✓ 2.0	D3353041	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LUG ARM WELDMENT

Batch: B47615

SAD

09-05-14

✓ 3.0	D3354041	Left Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-041	Left Arm Weldment	<u>B42476</u>

SAD

09-05-14

✓ 4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RIGHT ARM WELDMENT

batch: B36639

SAD

09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 47363A

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	<u>B44535</u>

6.0

D3397041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	<u>47618</u>

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	<u>m109654</u>

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	<u>71105735</u>

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	<u>16362</u>

W/O:		WORK ORDER CHANGES					
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Job Number: 47363A

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Seq. #:

Machine Or Operation:

Description :

✓

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN5-23A	Bolt

batch

M19278

SAD 09-05-14

✓

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN960JD516	Washer

batch

M110523

SAD 09-05-14

✓

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	CP21	1/8" Cotter Pin 2" long

batch

108200

SAD 09-05-14

✓

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	MS21042L5	Nut

batch

~~108200~~

109840

SAD 09-05-14

✓

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
1	SNF-34	SLOTTED NUT

batch

~~M110523~~

M111550

SAD 09-05-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

2116582

SAD 09-05-14

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

2116362

SAD 09-05-14

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

SAD 09-05-14

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/15 @

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P0047363

S 09/05/15 @

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/15 @

Job Completion



MF 09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

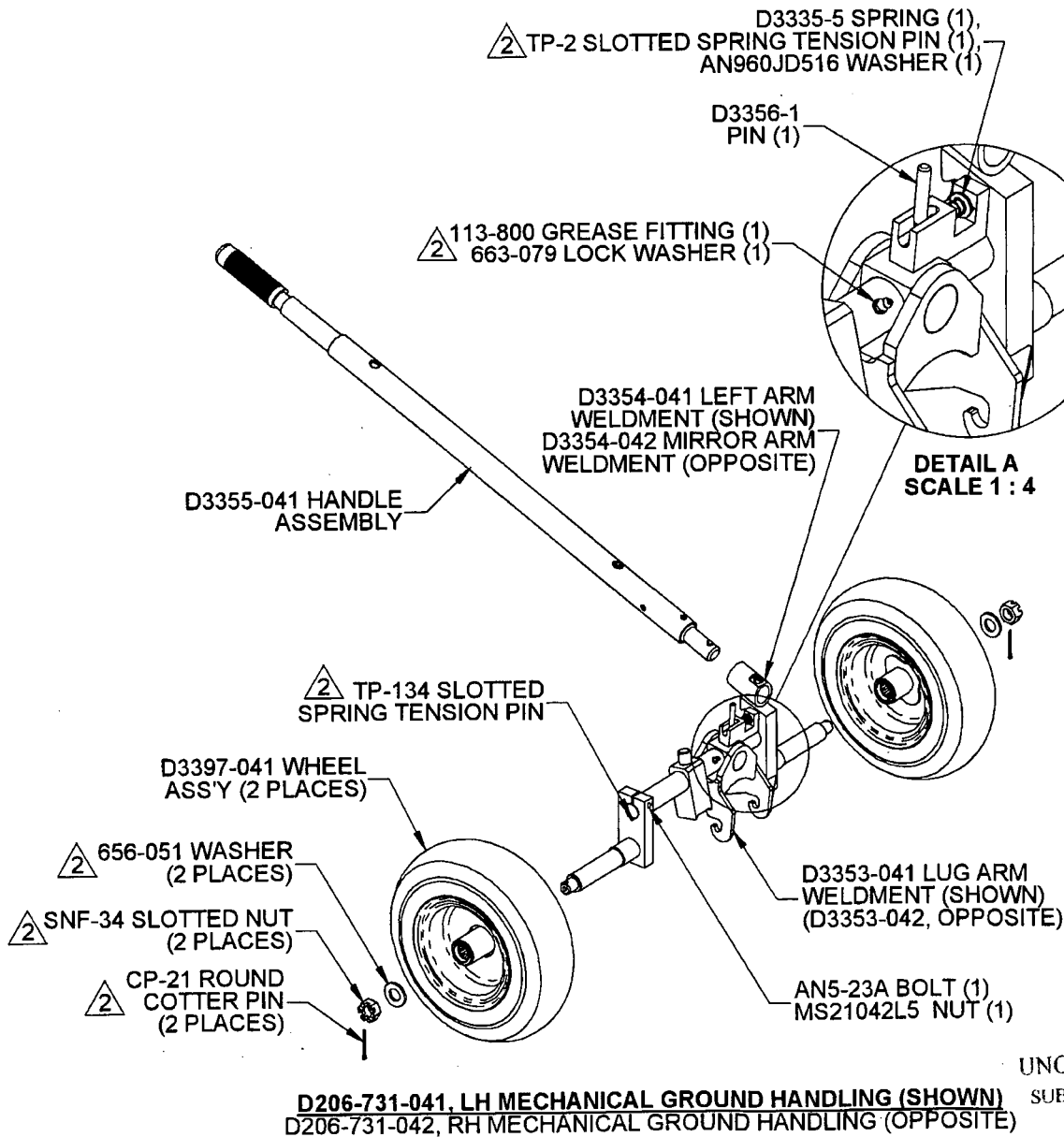
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.07.05

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47363A

NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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